

Work Order ID 111856-1 E 4706-041
January-23-14 2:40:49 PM

111856

Page 1

Item ID: E4706-041

Revision ID:

Item Name: Support Assembly

Start Date: 24/01/2014 Start Qty: 5.00

Required Date: 28/02/2014 Req'd Qty: 5.00

Reference:

B 11 1856

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: (P)

Date: 14-01-23

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

E4706

100

0.00

100

Purchasing

Purchasing

Memo

Purchasing

Issue P/O: 22776

Supplier: WEJAY.

Machine as per Dwg E4706-1

Conformity sheet required

0.00

CL 14/01/28 S

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

0.00

HX SP14-3-27

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 111856

January-23-14 2:40:49 PM

111856

Page:2

Item ID: E4706-041

Revision ID:

Item Name: Support Assembly

Start Date: 24/01/2014 Start Qty: 5.00 *5*

Required Date: 28/02/2014 Req'd Qty: 5.00 *5*

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: Date:

QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

Quality Control

0.00

130

Chemical Conversion Coat per OSI005 4.1

0.00

130

HandFinish

Memo

Hand Finishing

0.00

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Memo

Quality Control

0.00

u LPI / PRESSURE WASH
DAS 27 9/89
QC6 14/4/10 (4)

CL 14/04/08 4 P10: 23701

crest (5) 14/4/8

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 111856

January-23-14 2:40:49 PM

111856

Page 3

Item ID: E4706-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Support Assembly

Start Date: 24/01/2014 Start Qty: 5.00 *5*

Cust Item ID:

Required Date: 28/02/2014 Req'd Qty: 5.00 *5*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

141

141

SprayPaint

Spray Painting

Memo

PRIME AS PER DWG

128049

0.00

0.00

4

CN 14-04-08

~~14~~

142

142

QC

Quality Control

QC14- Inspect Spray Paint

Memo

0.00

0.00

Subtotal

4

143

143

Small Fab

Small Fab

Memo

INSERT BUSHING AS PER DWG

0.00

0.00

4x

14/04/07 DAS 36 7-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 111856

January-23-14 2:40:49 PM

111856

Page 4

Item ID: E4706-041

Revision ID:

Item Name: Support Assembly

Start Date: 24/01/2014 Start Qty: 5.00

Required Date: 28/02/2014 Req'd Qty: 5.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Run Start

NR1

Stop

NR2

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

144

QC5- Inspect part completeness to step on W/O

0.00

144

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location:

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

14/04/10

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

January-23-14 2:40:54 PM

Page: 1

Work Order ID: 111856

111856

Parent Item: E4706-041

F4706-041

Parent Item Name: Support Assembly

Start Date: 24/01/2014

Required Date: 28/02/2014

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 14-01-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
E4706-1P *F4706-1P* Support Bracket		Purchased	No				Each	0.0000		5			
NAS77A5-025 *NAS77A5-025* Bushing		Purchased	No				Each	4.0000		5			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST277			4						
				123039			4						
NAS77A6-031 *NAS77A6-031* Bushing		Purchased	No				Each	4.0000		5			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST277			4						
				123039			4						
NAS77A7-025 *NAS77A7-025* Bushing		Purchased	No				Each	4.0000		5			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST277			4						
				123039			4						
NAS77A8-031 *NAS77A8-031* Bushing		Purchased	No				Each	4.0000		5			
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST277			4						
				123039			4						

B111856

(42)

**

EPD 14/04/09

**

14/04/09

DAS
36
9-89

4
5

14/04/09

**

DAS
36
9-89

4
5

14/04/09

**

DAS
36
9-89

4
5

14/04/09

**

DAS
36
9-89

4

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

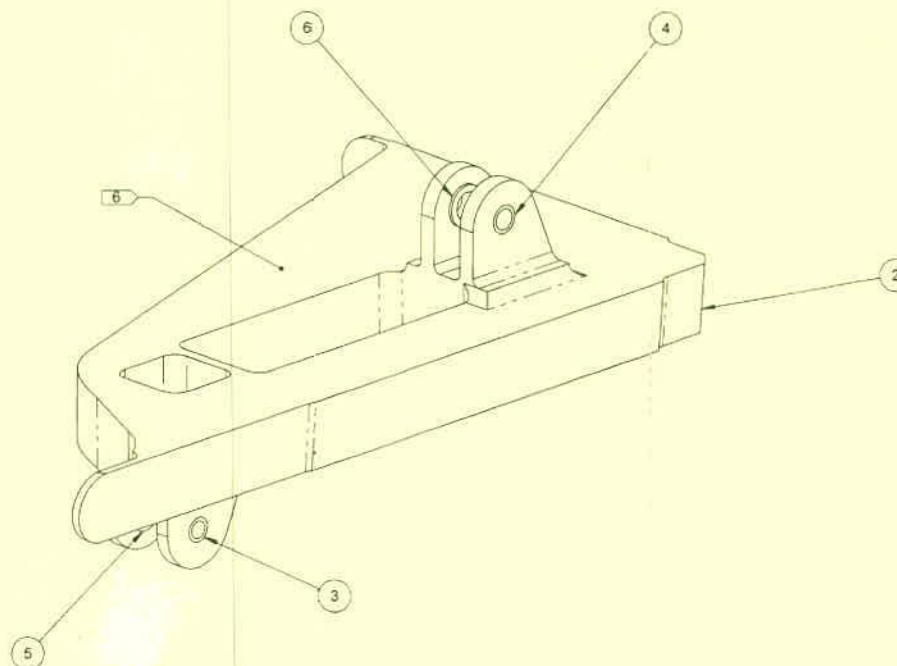
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	E4706-041	SUPPORT ASSEMBLY
2	1	E4706-1	SUPPORT BRACKET
3	1	NAS77A5-025	BUSHING
4	1	NAS77A6-031	BUSHING
5	1	NAS77A7-025	BUSHING
6	1	NAS77A8-031	BUSHING



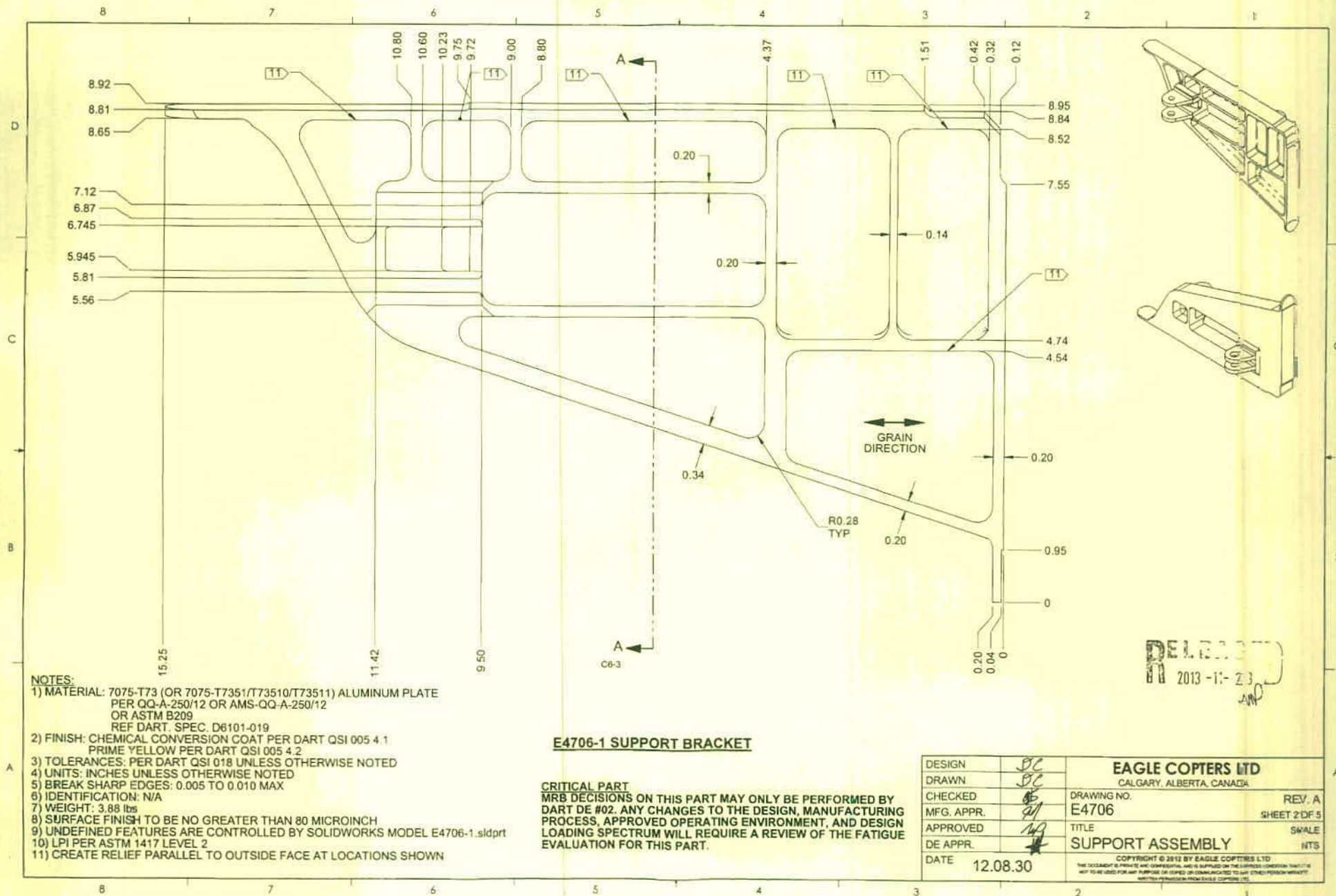
111856 *MP*
14-01-23

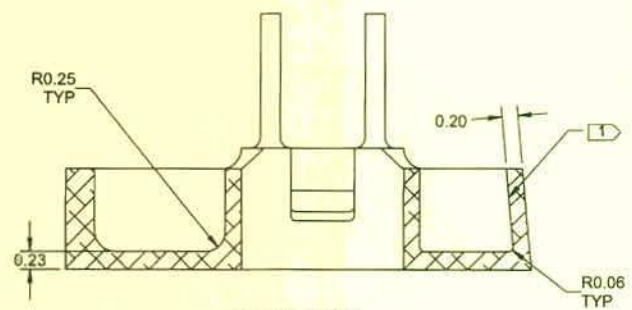
E4706-041 SUPPORT ASSEMBLY

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 3.93 lbs

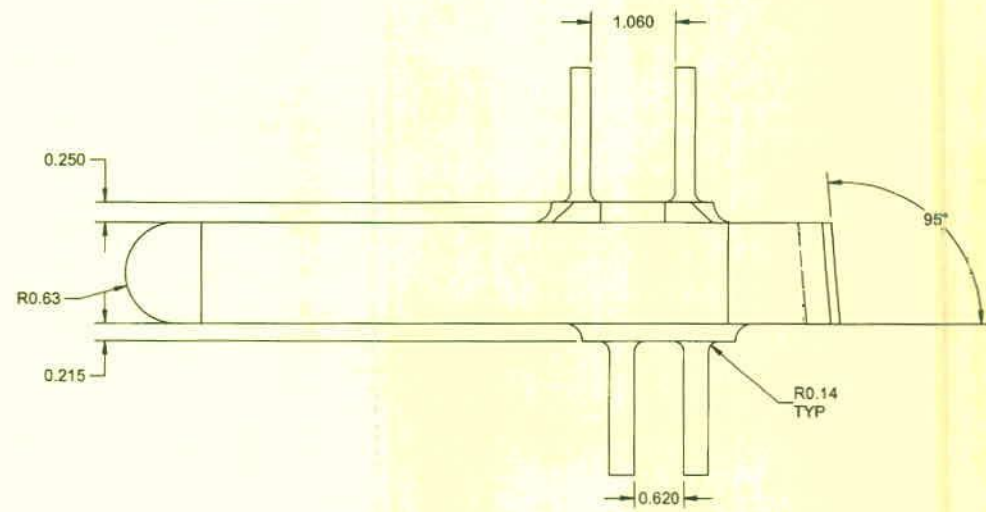
RELEASED
2013-11-23
MP

A	NEW ISSUE	DC	12-08-30
REV	DESCRIPTION	BY	DATE
DESIGN	<i>DC</i>	EAGLE COPTERS LTD	
DRAWN	<i>DC</i>	CALGARY, ALBERTA, CANADA	
CHECKED	<i>MP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>MP</i>	E4706	SHEET 1 OF 5
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	SUPPORT ASSEMBLY	ITS
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SECTION A-A
(ROTATED 90°)
B5-2



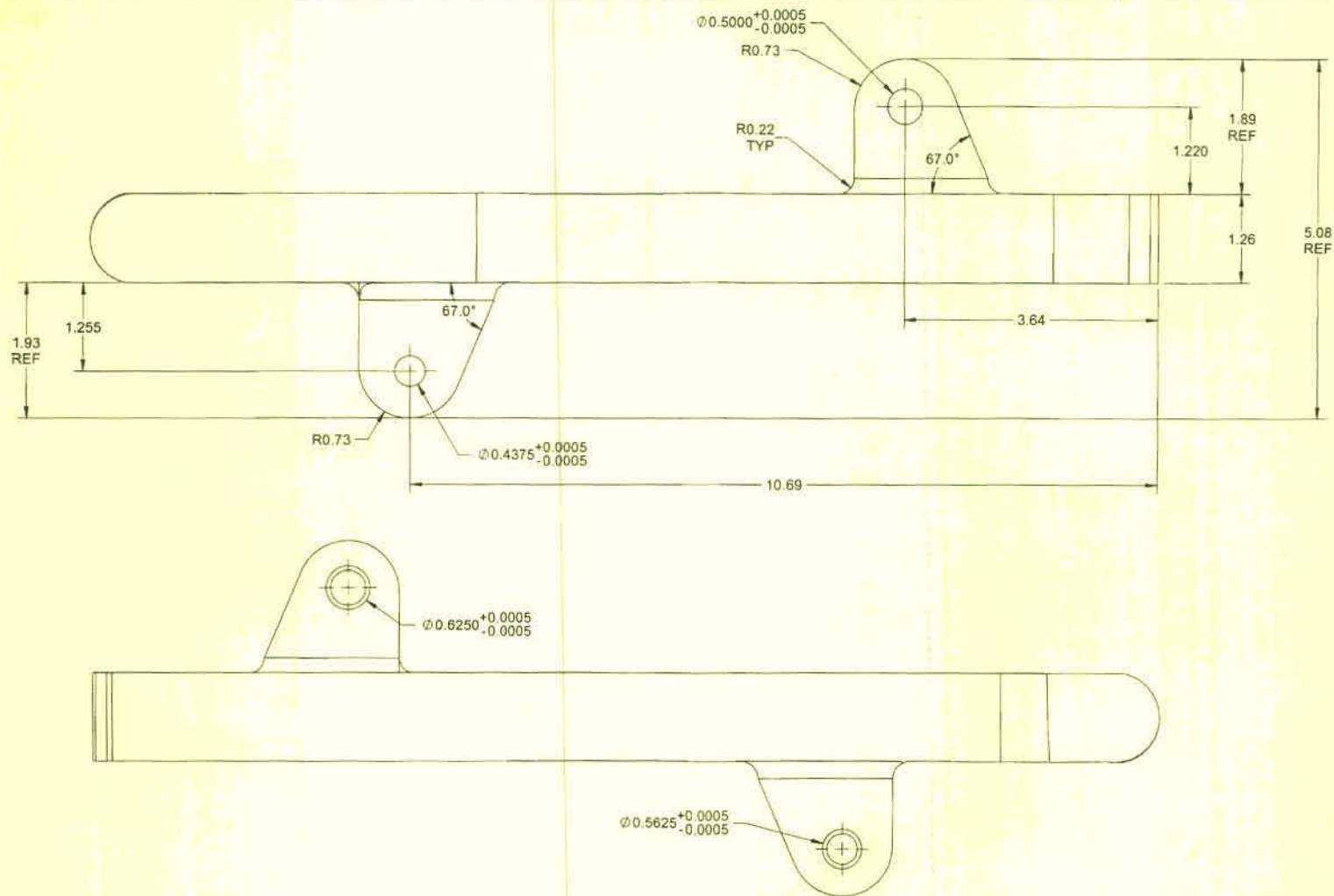
E4706-1 SUPPORT BRACKET
RIGHT VIEW

RELEASED
2013-11-28

NOTES:
*) CREATE RELIEF PARALLEL TO OUTSIDE FACE AT LOCATION SHOWN

DESIGN	BC
DRAWN	BC
CHECKED	BC
MFG. APPR.	BC
APPROVED	BC
DE APPR.	BC
DATE	12.08.30

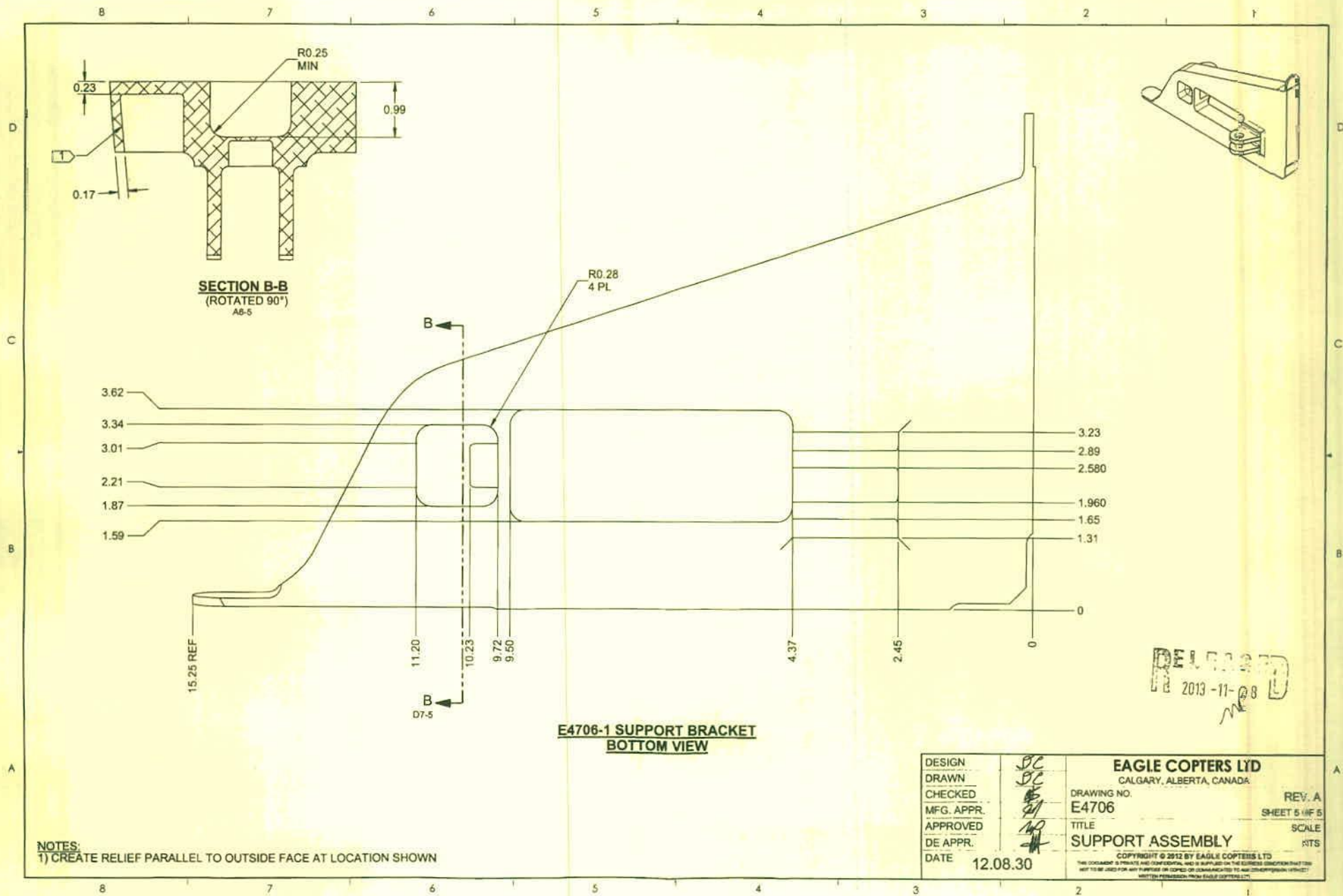
EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA	
DRAWING NO. E4706	REV. A
TITLE SUPPORT ASSEMBLY	SHEET 3 OF 5
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**E4706-1 SUPPORT BRACKET
SUPPLEMENTARY VIEWS**

DESIGN	DC	EAGLE COPTERS LTD	
DRAWN	DC	CALGARY, ALBERTA, CANADA	
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	JS	E4706	SHEET 4 OF 5
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	SUPPORT ASSEMBLY	MTS
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RELEASE
2013-11-23
MP





Packing Slip 3663

600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3
TEL: 613-384-1662 FAX: 613-384-2997
www.wejay.com

SOLD
TO
Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K7

SHIP
TO
Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K7

INVOICE DATE		YOUR ORDER NO. 9022776		DATE ORDERED 01/29/14		SHIPPED VIA FAST	
CUSTOMER CODE DART		PROV. LIC. NO.		Extra <input type="checkbox"/> Exempt <input type="checkbox"/>		TERMS	
QUANTITY ORDERED	B.O.	QUANTITY SHIPPED	DESCRIPTION			UNIT PRICE	AMOUNT
5	0	5	Fabricate ladder as per drawing E4702, Rev. A Ref: E4702-1P				
5	1	4	B111857 Fabricate support bracket as per drawing E4706, Rev. A Ref: E4706-1P B111656 Required by: March 24, 2014 RELEASE NOTE I certify that the items listed hereon have been inspected and tested and conform to all specifications and requirements in the contract or purchase order. Inspection Supervisor <i>[Signature]</i> WMP 03 MAR 26/14				
						G.S.T.	
						P.S.T.	

ORDER: COMPLETE ☐
PARTIAL ☐

TOTAL

RECEIVED BY _____
1.5% PER MONTH (18% PER ANNUM)
CHARGED ON OVERDUE ACCOUNTS

NO GOODS RETURNED WITHOUT
PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace	DATE: Mar. 14, 2014		
	P.O.# PO22776		
	WEJAY JOB# 36656		
I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below. Any exceptions will be listed as NCR items.			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
E4706-1 'Support Assembly'	4	Machined complete per drawing req'ts.	E4706 / rev. A
Note: 1) Material Test Report attached -ref. 'Alcoa Inc' Lot# 554091 (Wejay TN# 030025-2). 2) 1sst Article Dimensional Inspection report attached.			

Records of Inspection/Test will be retained for 5 years minimum.

Yours truly,

Clifford Smith

Authorized Q.A. Signatory



skyservice Work Order Traveler

Sky Service F.B.O. Inc.

Page: 1 of 2

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO20484	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: 23701
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN: 0	CSN: 0	TSO: 0	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON 23 MISC PARTS

ITEM ID: E4702-041 LADDER ASSY
1 - WORK ORDER ID#: 111875 (QTY5)

ITEM ID: E4706-041 SUPPORT ASSY
2 - WORK ORDER ID#: 111856 (QTY5)

ITEM ID: D4806-3 STUD
3 - WORK ORDER ID#: 115957 (QTY4)

ID#: D4807-041 SUPPORT ASSY
4 - WORK ORDER ID#: 111664 (QTY3)

ID#: D4882-1 STRUT
5 - WORK ORDER ID#: 115543 (QTY4)

ID#: D4883-1 END FITTING
6 - WORK ORDER ID#: 113533 (QTY4)

Action Taken:	Date:	Initial/Stamp:				
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-6) AS PER ASTM1417M-13 NO CRACK FOUND Pen: ZL-56 BATCH# 09H094 EXP. DATE: AUG 2014, DEV: SKD-S2 EXP. DATE: OCT2017 CLEANER: SKC-S EXP. DATE: APR 2018	APR 08 2014	 1				
Description	Location	P/N	Qty	Batch	S/N Off	S/N On

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date:
Name: ANTONINO MARCHETTA		APR 08 2014

CERTIFIED INSPECTION REPORT

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Per:

Rob Woodall

Rob Woodall
Director of Manufacturing Davenport Works

Terrance Thom

Terrance Thom
Quality Assurance Manager

1626049

0

Ship Date

B.L. No.

Invoice No.

Alcoa No. Item

2013-10-03

8817454

00000

1000507868-10

DP-07868-10

P.O. No./Govt Contract No.

Customer

Alcoa Item

048669

G041130019R02

Page 1 of 2

Ship To:

Item Description
5.5 IN TK (+.130 -.130) X 48.5 IN W (+.3125 -
0.000) X 144.5 IN LN (+.5 -0.0) (N) A/T 7075-
T7351 RECTANGLE MILL FINISH, USI 3MM DEAD ZONE REQ'D BOTH SIDES,
SAWED. EXC MRK, TK, PROP, ST COR AMS-QQ-A-
250/12 IS 2097 AMS-STD-2154 REV A EXC MRK, TK, PROP,
ST COR AMS4078 REV J EXC MRK, TK, PROP, ST COR
ASTMB209 REV 10 ASTMB594 REV 13 BSS7055 REV
A GAMPSS9101 REV B PS211211 REV L ((MARKED))
KRAFT PAPER INTERLEAVED MAX
GROSS SKID WGT: 5000 LB QUAN TOL +/-20 %
USI CL A 3 MM COR 0239480 REV 02 CUST REQ 13-09-
10 *** W/E 13-10-05 ***

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	560877	554091	3938	1	PC	47353

Notes for CQR: 0239480.2

THIS MATERIAL HAS BEEN ULTRASONICALLY INSPECTED FULLY IMMERSION - TYPE I.
PRODUCT PRODUCED TO THE REQUIREMENTS OF MIL-STD-2154 ALSO MEET THE REQUIREMENTS OF AMS-STD-2154 REV A. PRODUCT PRODUCED TO
THE REQUIREMENTS OF AMS-STD-2154 REV A ALSO MEET THE REQUIREMENTS OF MIL-STD-2154.

CQR: 0239480.2 -Specification Limits

Temp	Dir	UTS	TYS	EL4D
		KSI	KSI	PCT
T7351	Long Transv.	Max		
		Min	54	38
				5

T7351 Elec. Cond. (EC) % MIN 38.0 PCT

WMP
03

TN30025-20

36656
FEB 21/14
rec'd

CERTIFIED INSPECTION REPORT

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Per:

Rob Woodall

Rob Woodall
Director of Manufacturing Davenport Works

Terrance Thom

Terrance Thom
Quality Assurance Manager

Page 2 of 2

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

1626049 Ship Date	0 B.L. No.	Invoice No.	Alcoa No. Item	
2013-10-03	8817454	00000	1000507868-10	DP-07868-10
P.O. No./Govt Contract No.	Customer	Alcoa Item		
048669		G041130019R02		

COR: 0239480.2 -Specification Limits (cont.)

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Other	
									Each	Total Aluminum
Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15
Min			1.2		2.1	0.18	5.1			REMAIN

Notes for Lot: 554091

MAX TYS-LT VALUE IS AN INTERNAL LIMIT. OK PER C.M.K. & B.L.G.

Lot: 554091 - Mechanical, Physical, Metallography, Quantometer Results

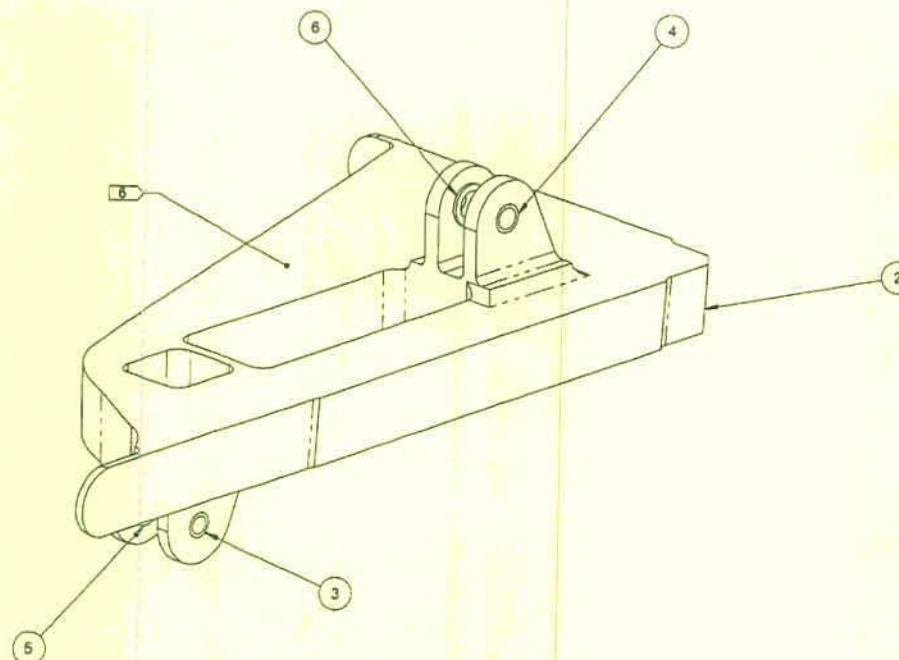
Tmpt	Dir	Test	UTS	TYS	EL&D
T7351	Long Transv.	2	64.2	51.8	9
			64.5	52.5	8.7

T7351 Elect Cond & IACS 40.8 40.5 PCT

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
H9204081		0.07	0.28	1.6	0.02	2.5	0.19	5.6	0.02

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	E4706-041	SUPPORT ASSEMBLY
2	1	E4706-1	SUPPORT BRACKET
3	1	NAS77A5-025	BUSHING
4	1	NAS77A6-031	BUSHING
5	1	NAS77A7-025	BUSHING
6	1	NAS77A8-031	BUSHING



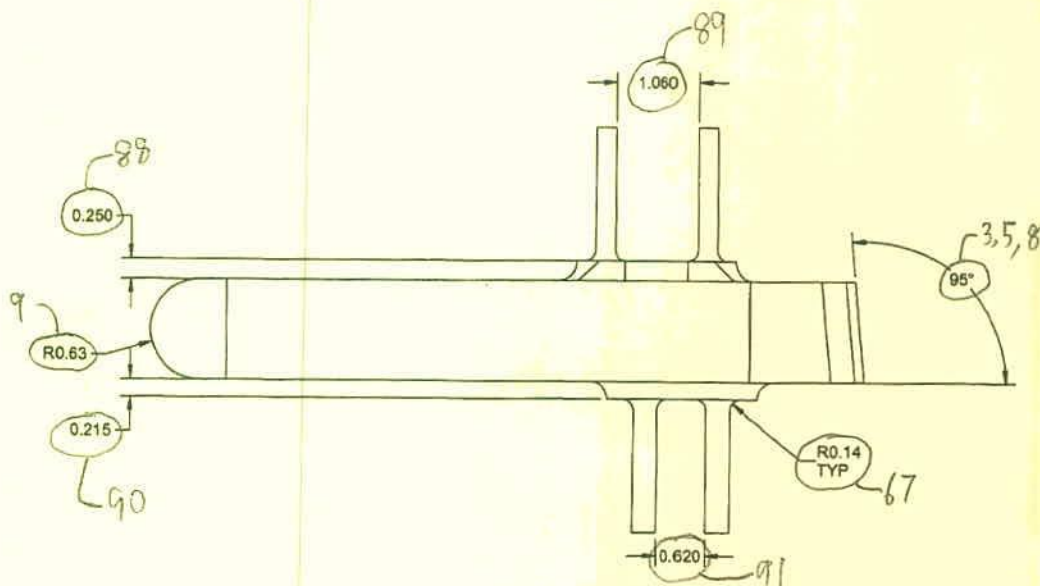
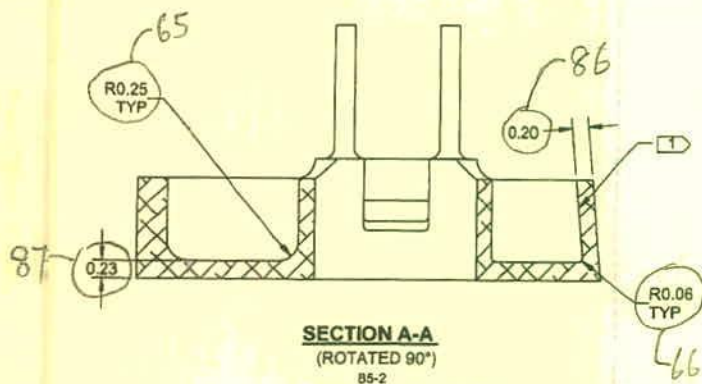
E4706-041 SUPPORT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.93 lbs

RELEASED
2013-11-23
MP

A	NEW ISSUE	DC	12.08.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BC	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA	
DRAWN	BC		
CHECKED	BT	DRAWING NO.	REV. A
MFG. APPR.	BT	E4706	SHEET 1 OF 5
APPROVED	BT	TITLE	SCALE
DE APPR.	BT	SUPPORT ASSEMBLY	NTS
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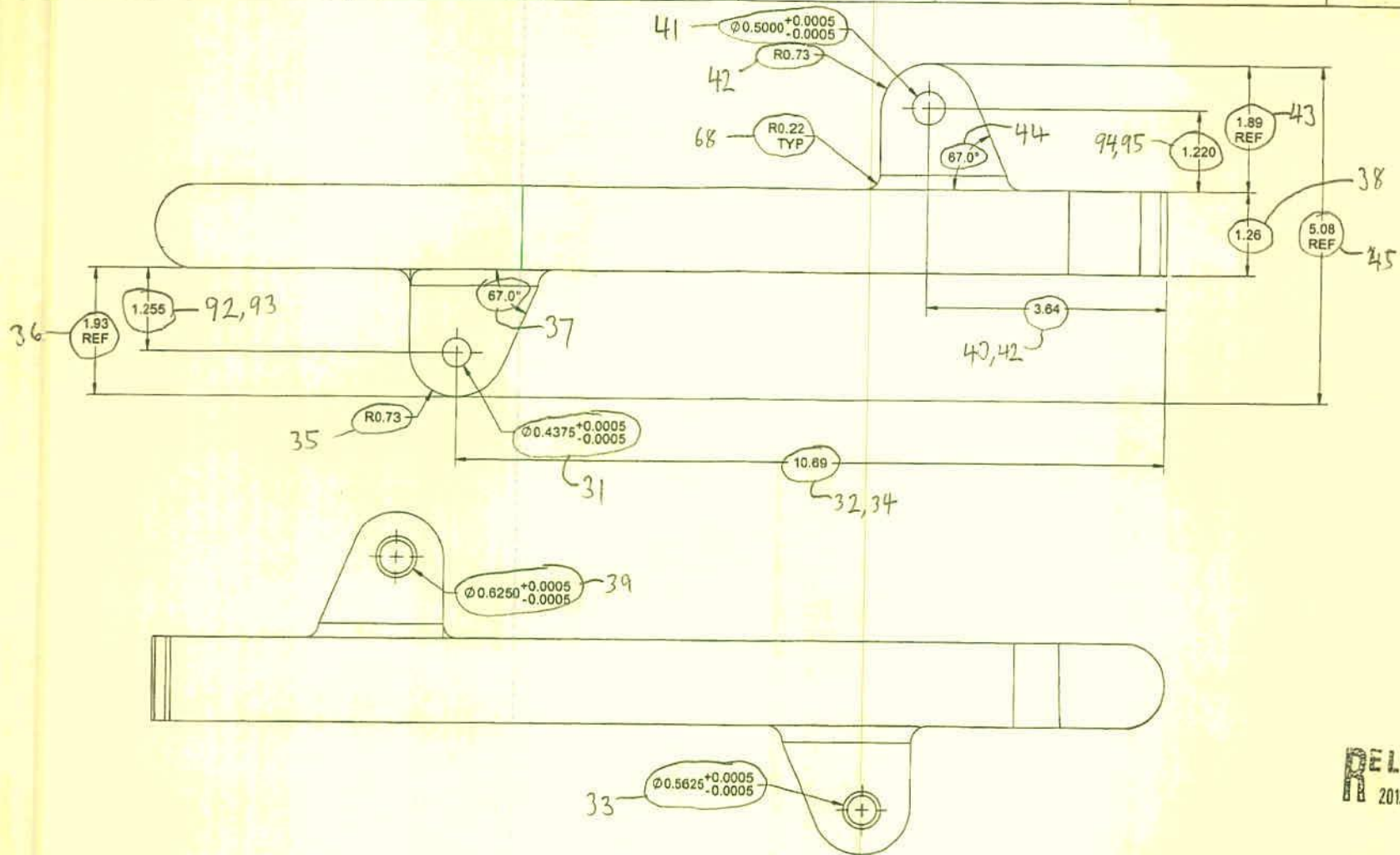


**E4706-1 SUPPORT BRACKET
RIGHT VIEW**

RELEASED
2013-11-23

NOTES:
1) CREATE RELIEF PARALLEL TO OUTSIDE FACE AT LOCATION SHOWN

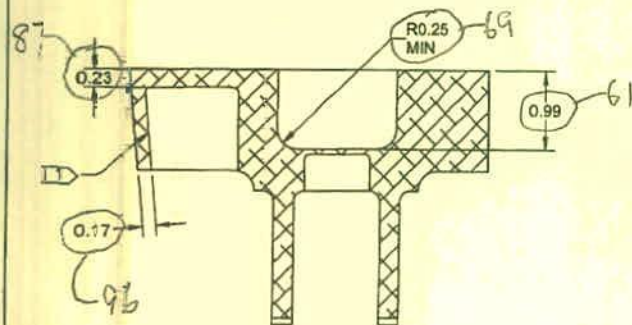
DESIGN	DL	EAGLE COPTERS LTD	
DRAWN	DL	CALGARY, ALBERTA, CANADA	
CHECKED	DL	DRAWING NO.	REV. A
MFG. APPR.	DL	E4706	SHEET 3 OF 3
APPROVED	DL	TITLE	SCALE
DE APPR.	DL	SUPPORT ASSEMBLY	NTS
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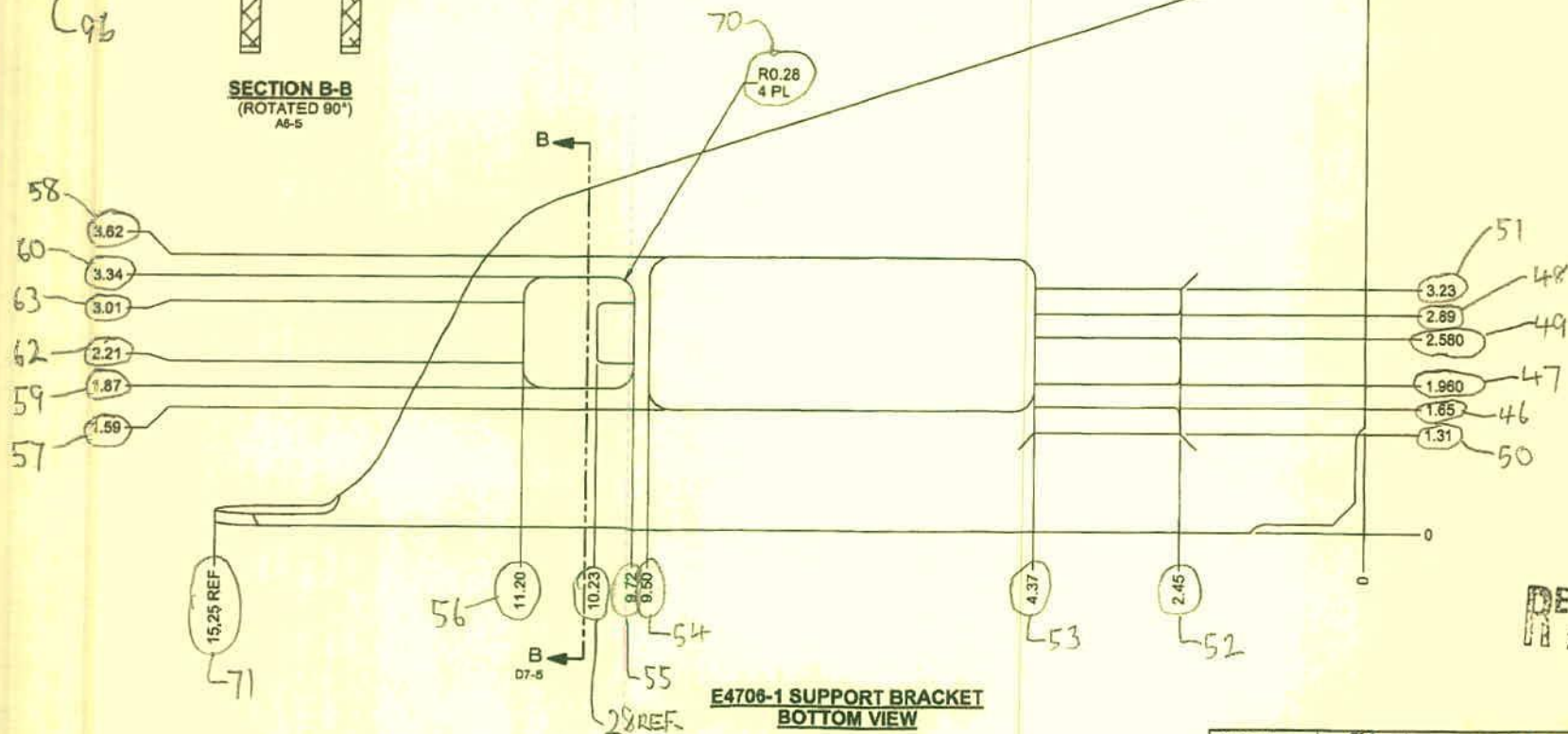
**E4706-1 SUPPORT BRACKET
SUPPLEMENTARY VIEWS**

DESIGN	DC	EAGLE COPTERS LTD	
DRAWN	DC	CALGARY, ALBERTA, CANADA	
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DC	E4706	SHEET 4 OF 5
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	SUPPORT ASSEMBLY	NTS
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RELEASED
2013-11-28
MD



SECTION B-B
(ROTATED 90°)
A6-5



E4706-1 SUPPORT BRACKET
BOTTOM VIEW

NOTES:
1) CREATE RELIEF PARALLEL TO OUTSIDE FACE AT LOCATION SHOWN

DESIGN	BC	EAGLE COPTERS LTD	
DRAWN	BC	CALGARY, ALBERTA, CANADA	
CHECKED	BC	DRAWING NO.	REV. A
MFG. APPR.	BC	E4706	SHEET 5 OF 5
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	SUPPORT ASSEMBLY	NBS
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RELEASED
2013-11-08



Customer Dart Aerospace Customer P.O. PO22776
 Drawing # E4706 Drawing rev A
 Part Number E4706-1 E.C.O. -
 Part Name Support Bracket Material Alum. Alloy 7075-T7351 per ASTM B209
 Serial # 001 Inspected by Cliff Smith
 Job # 36656 Signature:



ACCEPTED

Comment: Side 1



Overall Result

All Characteristics: 66
 Out of tolerance: 0
 Over Warning Limit: 0
 Not Calculated: 0

Feature	ID	Actual	Nominal	Pos Tol.	Neg Tol.	Deviation	<-- -->
■ Datum Face 1 Flat ref	GDT Flat	0.0020	0.0000	0.0050		0.0020	-
■ 1 2_D2	Y	8.9447	8.9500	0.0300	-0.0300	-0.0053	-
■ 2 2_D2	Y	-8.8346	-8.8400	0.0300	-0.0300	0.0054	-
■ 3 3_C1	A	94.9957	95.0000	0.5000	-0.5000	-0.0043	-
■ 4 2_D2	Y	8.8316	8.8400	0.0300	-0.0300	-0.0084	-
■ 5 3_C1	A	94.9988	95.0000	0.5000	-0.5000	-0.0012	-
■ 6 2_D8	Y	8.9157	8.9201	0.0300	-0.0300	-0.0044	-
■ 7 2_D8	Y	8.8054	8.8099	0.0300	-0.0300	-0.0045	-
■ 8 3_C2	A	95.0183	95.0000	0.5000	-0.5000	0.0183	-
■ 9 3_C5	R	0.6287	0.6300	0.0300	-0.0300	-0.0013	-
■ 10 2_D2	X	-0.1150	-0.1200	0.0300	-0.0300	0.0050	-
■ 11 2_D3	X	-0.4183	-0.4200	0.0300	-0.0300	0.0017	-
■ 12 2_D3	X	-1.5073	-1.5100	0.0300	-0.0300	0.0027	-
■ 13 2_D6	X	-9.7523	-9.7500	0.0300	-0.0300	-0.0023	-
■ 14 2_B8	ResEle	-15.2487	-15.2500	0.0300	-0.0300	0.0013	-
■ 15 2_D8	Y	8.6509	8.6500	0.0300	-0.0300	0.0009	-
■ 16 2_B2	Y	0.9552	0.9500	0.0300	-0.0300	0.0052	-
■ 18 2_D2	Y	8.5209	8.5200	0.0300	-0.0300	0.0009	-
■ 19 2_D2	Y	8.5210	8.5200	0.0300	-0.0300	0.0010	-
■ 20 2_B6	X	-9.5004	-9.5000	0.0300	-0.0300	-0.0004	-
■ 21 2_B6	X	-11.4171	-11.4200	0.0300	-0.0300	0.0029	-
■ 22 2_C8	Y	5.5581	5.5600	0.0300	-0.0300	-0.0019	-
■ 23 2_C8	Y	5.8058	5.8100	0.0300	-0.0300	-0.0042	-
■ 24 2_D8	Y	6.8679	6.8700	0.0300	-0.0300	-0.0021	-
■ 25 2_D8	Y	7.1157	7.1200	0.0300	-0.0300	-0.0043	-
■ 25 2_C8	Y	5.9429	5.9450	0.0100	-0.0100	-0.0021	-
■ 26 2_D8	Y	6.7434	6.7450	0.0100	-0.0100	-0.0016	-
■ 27 2_D6	X	-9.7228	-9.7200	0.0300	-0.0300	-0.0028	-
■ 28 2_D6	X	-10.2420	-10.2300	0.0600	-0.0600	-0.0120	-
■ 29a 2_D4	X	-4.3660	-4.3700	0.0300	-0.0300	0.0040	-
■ 29b 2_D4	X	-4.3656	-4.3700	0.0300	-0.0300	0.0044	
■ 29c 2_D4	X	-4.3645	-4.3700	0.0300	-0.0300	0.0055	-

Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-->
23 Perp to body surf ref	GDT Perp	0.0014	0.0000	0.0050		0.0014	-
24 Parallel to 23 ref	GDT Par	0.0013	0.0000	0.0050		0.0013	-
30a 3_C8	Z	-1.0383	-1.0400	0.0300	-0.0300	0.0017	-
30b 3_C8	Z	-1.0387	-1.0400	0.0300	-0.0300	0.0013	-
30c 3_C8	Z	-1.0371	-1.0400	0.0300	-0.0300	0.0029	-
30d 3_C8	Z	-1.0388	-1.0400	0.0300	-0.0300	0.0012	-
30e 3_C8	Z	-1.0392	-1.0400	0.0300	-0.0300	0.0008	-
30f 3_C8	Z	-1.0385	-1.0400	0.0300	-0.0300	0.0015	-
30g 3_C8	Z	-1.0375	-1.0400	0.0300	-0.0300	0.0025	-
31 4_C5	D	0.4371	0.4375	0.0005	-0.0005	-0.0004	-
Cylindricity .4375 dia	GDT Cyl	0.0003	0.0000	0.0005		0.0003	-
Cylindricity .5625 dia1	GDT Cyl	0.0004	0.0000	0.0005		0.0004	-
32 4_C4	X	-10.6958	-10.6900	0.0300	-0.0300	-0.0058	-
33 4_A4	D	0.5625	0.5625	0.0005	-0.0005	0.0000	-
34 4_C4	X	-10.6956	-10.6900	0.0300	-0.0300	-0.0056	-
35 4_C6	R	0.7291	0.7300	0.0300	-0.0300	-0.0009	-
36 4_C8	ResEle	1.9197	1.9300	0.0300	-0.0300	-0.0103	-
37 4_C6	A	66.9872	67.0000	0.5000	-0.5000	-0.0129	-
77 2_C2	Y	4.7341	4.7400	0.0300	-0.0300	-0.0059	-
78 2_C2	Y	4.5363	4.5400	0.0300	-0.0300	-0.0037	-
79 2_B2	3d Dist	0.1967	0.2000	0.0300	-0.0300	-0.0033	-
80 2_B3	3d Dist	0.1952	0.2000	0.0300	-0.0300	-0.0048	-
81 2_B4	3d Dist	0.3431	0.3448	0.0300	-0.0300	-0.0017	-
82 2_C3	3d Dist	0.1434	0.1400	0.0300	-0.0300	0.0034	-
83 2_C4	3d Dist	0.2022	0.2000	0.0300	-0.0300	0.0022	-
84 2_D4	3d Dist	0.1980	0.2000	0.0300	-0.0300	-0.0020	-
86 3_C6	3d Dist	0.1985	0.2000	0.0300	-0.0300	-0.0015	-
88 3_C5	Z	0.2516	0.2500	0.0039	-0.0300	0.0016	-
89 3_C2	CartDist	1.0618	1.0600	0.0100	-0.0100	0.0018	-
92 4_D2	Z	1.2514	1.2550	0.0100	-0.0100	-0.0036	-
93 4_D2	Z	1.2536	1.2550	0.0100	-0.0100	-0.0014	-
96 5_D8	3d Dist	0.1688	0.1692	0.0300	-0.0300	-0.0004	-



Customer Dart Aerospace Customer P.O. PO22776
 Drawing # E4706 Drawing rev A
 Part Number E4706-1 E.C.O. -
 Part Name Support Bracket Material Alum. Alloy 7075-T7351 per ASTM B209
 Serial # 001 Inspected by Cliff Smith
 Job # 36656 Signature:



Comment: Side 2



Overall Result

All Characteristics: 36
 Out of tolerance: 0
 Over Warning Limit: 0
 Not Calculated: 0

Feature	ID	Actual	Nominal	Pos Tol.	Neg Tol.	Deviation	<-- -->
38 4_D2	Z	-1.2594	-1.2600	0.0300	-0.0300	0.0006	-
top and bott surfs Parallel ref	GDT Par	0.0008	0.0000	0.0100		0.0008	-
39 4_B6	D	0.6251	0.6250	0.0005	-0.0005	0.0001	-
40 4_C3	X	-3.6373	-3.6400	0.0300	-0.0300	0.0027	-
41 4_D4	D	0.5000	0.5000	0.0005	-0.0005	0.0000	-
42 4_C3	X	-3.6372	-3.6400	0.0300	-0.0300	0.0028	-
42 4_D4	R	0.7301	0.7300	0.0300	-0.0300	0.0001	-
43 4_D2	ResEle	1.8885	1.8900	0.0300	-0.0300	-0.0015	-
44 4_D3	A	67.0067	67.0000	0.5000	-0.5000	0.0067	-
45 4_D2	ResEle	5.0679	5.0800	0.0300	-0.0300	-0.0121	-
46 5_B2	Y	1.6503	1.6500	0.0300	-0.0300	0.0003	-
47 5_B2	Y	1.9600	1.9600	0.0100	-0.0100	0.0000	-
48 5_C2	Y	2.8881	2.8900	0.0300	-0.0300	-0.0019	-
49 5_B2	Y	2.5780	2.5800	0.0100	-0.0100	-0.0020	-
47 Perp to body surf ref	GDT Perp	0.0003	0.0000	0.0050		0.0003	-
49 Parallel to 47 ref	GDT Par	0.0004	0.0000	0.0060		0.0004	-
50 5_B2	Y	1.3080	1.3100	0.0300	-0.0300	-0.0020	-
51 5_C2	Y	3.2298	3.2300	0.0300	-0.0300	-0.0002	-
52 5_B3	X	-2.4443	-2.4500	0.0300	-0.0300	0.0057	-
53 5_B4	X	-4.3657	-4.3700	0.0300	-0.0300	0.0043	-
54 5_B6	X	-9.5007	-9.5000	0.0300	-0.0300	-0.0007	-
55 5_B6	X	-9.7222	-9.7200	0.0300	-0.0300	-0.0022	-
56 5_B6	X	-11.1977	-11.2000	0.0300	-0.0300	0.0023	-
57 5_B8	Y	1.5888	1.5900	0.0300	-0.0300	-0.0012	-
58 5_C8	Y	3.6192	3.6200	0.0300	-0.0300	-0.0008	-
59 5_B8	Y	1.8674	1.8700	0.0300	-0.0300	-0.0026	-
60 5_C8	Y	3.3430	3.3400	0.0300	-0.0300	0.0030	-
61 5_D6	Z	-0.9853	-0.9900	0.0300	-0.0300	0.0047	-
62 5_B8	Y	2.2018	2.2100	0.0300	-0.0300	-0.0082	-
63 5_C8	Y	3.0016	3.0100	0.0300	-0.0300	-0.0084	-
90 3_B5	Z	0.2167	0.2150	0.0300	-0.0300	0.0017	-
91 3_R2	CartDist	1.2384	1.2400	0.0100	-0.0100	-0.0016	-

Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<- ->
94 4_D2	Z	1.2214	1.2200	0.0100	-0.0100	0.0014	-
95 4_D2	Z	1.2195	1.2200	0.0100	-0.0100	-0.0005	-

Manually Inspected Features

64	2_B3	R0.28 typ.	<u>R.28 TYP.</u>
65	3_C8	R0.25 typ.	<u>R.25 TYP.</u>
66	3_B5	R0.06 typ.	<u>R.06 TYP.</u>
67	3_B2	R0.14 typ.	<u>R.14 TYP.</u>
68	4_D4	R0.22	<u>R.22 TYP.</u>
69	5_D7	R0.25 min.	<u>R.25</u>
70	5_C5	R0.28 4 pl.	<u>R.28 TYP.</u>
71	5_A8	15.25 ref.	<u>15.251</u>
72	2_A8	Deburring per note 5	<u>O.K.</u>
73	2_A8	Surface finish per note 11	<u>≤ 55 R_A</u>
74	2_A8	Relief parallel to outside face	<u>O.K.</u>
75	2_A3	0.20 dim	<u>.200/.201</u>
76	2_D3	0.32 dim	<u>.316/.317</u>
85	2_B4	R0.28 typ.	<u>R.28 TYP.</u>
87	3_B8	0.23 wall typ.	<u>.225/.230</u>
86	3_C5	0.20 DIM	<u>.198/.199</u>

Clifford Smith

From: Scott Dennis [scott@wejay.com]
Sent: Friday, March 14, 2014 11:30 AM
To: Clifford Smith
Subject: Fw: Dart PO# PO22776

-----Original Message-----

From: Jean-Luc Menard
Sent: Friday, March 14, 2014 10:45 AM
To: 'Scott Dennis (scott@wejay.com)'
Subject: FW: Dart PO# PO22776

Here you go.
JL

From: Daniel Campbell
Sent: March-14-14 10:29 AM
To: Jean-Luc Menard
Subject: RE: Dart PO# PO22776

Yes, I think it's ok.

Cheers,
Dan

From: Jean-Luc Menard
Sent: March-14-14 5:48 AM
To: Daniel Campbell
Subject: RE: Dart PO# PO22776

So are you ok with that?
JL

From: Jean-Luc Menard
Sent: March-13-14 5:23 PM
To: Daniel Campbell
Subject: Re: Dart PO# PO22776

We install them, and yes I agree.
JL

Sent from my iPhone

On Mar 13, 2014, at 4:45 PM, "Daniel Campbell"
<dcampbell@dartaero.com<mailto:dcampbell@dartaero.com>> wrote:
Hi JL,

Does Dart install the bushing or Wejay?

As long as the bushing can be securely press fit into the hole, I don't think it will matter.

What do you think?

Thanks,
Dan

From: Jean-Luc Menard
Sent: March-13-14 2:25 PM

* To: Daniel Campbell
Cc: Scott Denis
Subject: Fwd: Dart PO# PO22776

Hi Dan,
See below for The question from QA at weejay, Thx JL

Sent from my iPhone

Begin forwarded message:

From: Scott Dennis <scott@wejay.com<mailto:scott@wejay.com>>

Date: March 13, 2014 at 4:21:43 PM EDT

To: Jean-Luc Menard <jmenard@dartaero.com<mailto:jmenard@dartaero.com>>

Subject: Dart PO# PO22776

Hello Jean-Luc, Please see the comments below from our QA manager and advise me how to proceed.

Thanks again.

Scott

From: Clifford Smith<mailto:clifford@wejay.com>

Sent: Thursday, March 13, 2014 4:02 PM

To: 'Scott Dennis'<mailto:scott@wejay.com>

Subject: MDA PO# PO22776

Hi Scott,

We have 1 piece part# E4706-1 rev. A that has an oversize condition of .0003" on the .4375 +/- .0005 dia hole. i.e. actual size = .4383"

according to NAS specs, the bushing for this hole (NAS77A5-025 from dwg sheet 1) will be .4386+.000/- .0005".

Do you want to inquire with Dart about this or should I make out an NCR?

Cliff

[<http://static.avast.com/emails/avast-mail-stamp.png>]<http://www.avast.com/>>

This email is free from viruses and malware because avast!
Antivirus<http://www.avast.com/> protection is active.

This email is free from viruses and malware because avast! Antivirus protection is active.
<http://www.avast.com>



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO22776**

Purchase Order Date 1/24/2014

PO Print Date 1/28/2014

Page Number 1 of 1

Order From :

VC-WMP001

Ship To : DART AEROSPACE LTD

WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
2/14/2014

Contact Name

Vendor Phone

613-384-1662

Buyer

Customer POID

Chantal Lavoie

Customer Tax #

10127-2607

Ship To Contact

Ship To Phone

Terms

COD

Ship Via:

FedEx PI collect

Currency

CAD

Ship Acct:

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extens Pr
1	E4702-1P	Ladder	3/28/2014 Yes 3/24/2014		5.00 ✓ Each	\$1,910.00	\$9,550

MACHINE AS PER DWG E4702 REV. A
B111857

QUOTATION NO. WJ-7672

Line Total: \$9,550

2	E4706-1P	Support Bracket	3/24/2014 Yes 3/24/2014		5.00 Each	\$2,330.00	\$11,650
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MACHINE AS PER DWG E4706 REV. A
B111856

QUOTATION NO. WJ-7672

Line Total: \$11,650

PO Total: \$21,200

PO Instructions:

Procurement Quality Clauses

A004-FAA-PMA/TSO

A005-Right of Entry

A008-First Article Inspection (FAI) by seller, (Documentation sent to Dart Aerospace)

A011-Delegations-Supplier Verification of Dart Aerospace Product

A012-Chemical and Physical Reports

A016-Personnel Qualification

A026-Certificate of Material Conformance

A041-Quality Management System

CL
M. Eugene



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO22776

Purchase Order Date 1/24/2014

PO Print Date 3/28/2014

Page Number 1 of 2

Order From :
WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

VC-WMP001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 613-384-1662

Ship To Contact
Ship To Phone

Ship Via FedEx PI collect
Ship Acct

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms COD
Currency CAD
FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req. Qty/ Unit of Measure	PO Unit Price	Extended Price
1	E4702-1P	Ladder	3/28/2014 Yes 3/31/2014		5.00 Each	\$1,910.00	\$9,550.00
	MACHINE AS PER DWG E4702 REV. A B111857 QUOTATION NO. WJ-7672						
Line Total:							\$9,550.00
2	E4706-1P	Support Bracket	3/24/2014 Yes 3/31/2014		4.00 Each	\$2,330.00	\$9,320.00
	MACHINE AS PER DWG E4706 REV. A B111856 QUOTATION NO. WJ-7672						

PO Instructions: Procurement Quality Clauses
A004-FAA-PMA/TSO
A005-Right of Entry
A008-First Article Inspection (FAI) by seller,(Documentation sent to Dart Aerospace)
A011-Delegations-Supplier Verification of Dart Aerospace Product
A012-Chemical and Physical Reports
A016-Personnel Qualification
A026-Certificate of Material Conformance
A041-Quality Management System



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO22776

Purchase Order Date 1/24/2014

PO Print Date 3/28/2014

Page Number 2 of 2

Order From :
WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

VC-WMP001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 613-384-1662

Ship To Contact
Ship To Phone

Ship Via FedEx PI collect
Ship Acct

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms COD
Currency CAD
FOB Destination-Collect

2	E4706-1P	Support Bracket	3/28/2014	1.00	\$2,030.00	\$2,030.00
			Yes	Each		
			3/31/2014			

delivery for one pcs will be 28 of march
1 pcs was scrap but Wejay will replace and re-order material

Line Total: \$11,350.00

PO Total: \$20,900.00

PO Instructions: Procurement Quality Clauses
A004-FAA-PMA/TSO
A005-Right of Entry
A008-First Article Inspection (FAI) by seller,(Documentation sent to Dart Aerospace)
A011-Delegations-Supplier Verification of Dart Aerospace Product
A012-Chemical and Physical Reports
A016-Personnel Qualification
A026-Certificate of Material Conformance
A041-Quality Management System

CL

